



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D4776-1
Job Sheet 192773



Part No: D4776-1

Job Qty: ~~30 pcs~~ **44 PCS**

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/19

Job Tracking No:

Due Date: 4/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4776 REV:E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	30 pcs		4/22/19	0.54	15.96	Doosan - 1		[Signature]
105	QC 2	30 pcs		4/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S175961



Part: D4776-1

Job No: 192773

Serial No/Batch: S175961

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/28/19

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111 QC 8	30 pcs	4/22/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.P 19-04-30
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
112 Handfinish - 1-1 Chemical-B4B	30 pcs	4/22/19	0.00 0.86	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/04/30
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 -	

				B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
113	QC 7	30 pcs	4/22/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
115	Powdercoat - 1 White Gl(A)- B4B	30 pcs	4/22/19	0.00 0.35	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
116	QC 3	30 pcs	4/22/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
130	Packaging 3-1 - Stock - B4B	30 pcs	4/22/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS 30 9:39
				Packaging 3 - 9 - B4B	APR 30 2019
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	30	4/22/19	0.00	0.00
		pcs			
				QC 21 - SA - 21	DAS 21 9:39
				QC 21 - SA - 70	MAY 01 2019
				QC 21 - SA - 53	9:39

Part Op **100** - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: _____ & Dwg D4776 Rev: _____ 2 -Deburr per dwg D4776
 Descriptions: **105** - (QC2- Inspect parts off machine FAI/FAIB)
111 - (QC8- Inspect parts - second check)
112 - (Chemical Conversion Coat per QSI005 4.1)
113 - (QC7-Inspect Chemical Conversion Coat)
115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME:
 _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
116 - (QC3- Inspect Part Finish)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	10.2300 ft (.341 ea) <i>*361 ea</i>	100-Doosan - 1	<u>5152386</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.500	10	20	0

46 5/8
14 FT
14 FT
14 FT

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		0.881
2	Basket Strut Clevis	0.438Inches $\pm$ 0.010	0.448 0.428		0.438
3	Basket Strut Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		0.375
4	Basket Strut Clevis	0.625Inches $\pm$ 0.010	0.635 0.615		0.625
5	Basket Strut Clevis	1.750Inches $\pm$ 0.030	1.780 1.720		1.750
6	Basket Strut Clevis	3.500Inches $\pm$ 0.030	3.530 3.470		3.499
7	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	45°
8	Basket Strut Clevis	0.030Inches $\pm$ 0.030	0.060 0.000		0.030
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	0.060
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	0.200
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	0.263
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	Radius	0.410
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		1.131
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178		0.188
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		0.182
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		0.500
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740		0.750
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	0.399
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	0.130
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750		0.758
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130		0.155
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	45°

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By Lead hand / Supervisor QC / QA Coordinator	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			